

Date: Thursday, 23/04/2009 3:24:06 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CONSOLE BRACKET HI-SLOPE
Job Number : 47414	
Estimate Number : 11004	
P.O. Number :	Part Number : D2606
This Issue : 23/04/2009 S.O. No. :	Drawing Number : D2606 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A1
Previous Run : 38590	Material :
Written By :	Due Date : 29/04/2009 Qty: 6 Um: Each
Checked & Approved By : <u>JUD 09.04.24</u>	
Comment : Est. D 98.11.26 Added Inspection DM Est Rev:E Now On Waterjet 07-03-22 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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**Comment:** Qty.: 0.1582 sf(s)/Unit Total: 0.9494 sf(s)

2024-T3 .040 sheet

Material: 2024-T3 (QQ-A-250/4) 0.040" thick

Stack of 10

(M2024T3S.040) Batch 11381 B 9-5-14

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D2606

Dwg Rev: A1Prog Rev: A1B 9-5-14

⑥

2-Deburr if necessary B 9-5-14

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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B 9-5-14**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK
S 09/05/14 ⑥ x6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 23/04/2009 3:24:06 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE BRACKET HI-SLOPE

Job Number: 47414

Part Number: D2606

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Deburr

Form as per Dwg D2606

PTD
SB 09/05/19 (5)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/05/19 (X5)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

UMD 09/05/20 (15)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-05-20 (25)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 3A

9/5/21

SP

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/21 (25)

Job Completion



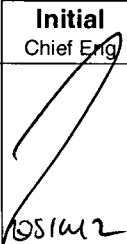
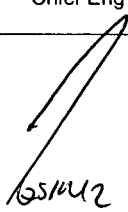
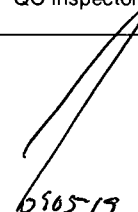
mf 09-05-21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2606 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: AD Date: 09/05/25

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>47414</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/05/19	5	1 piece broke at the forming R-c process	 05/11/12	Scrap & destroy no replace.	SP 09/05/19	S 09/05/19	 05/11/12	 05/05/19

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 47414
Description: Console Bracket		Part Number: D2606
Inspection Dwg: D2606 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.841	+/-0.005	.843	X			
1.589	+/-0.005	1.590	X			
0.621	+/-0.010	.622	X			
1.809	+/-0.010	1.810	X			
2.430	+/-0.010	2.433	X			
0.621	+/-0.010	.620	X			
8.309	+/-0.010	8.305	X			
8.930	+/-0.010	8.932	X			
8.710	+/-0.010	8.711	X			
R0.250	+/-0.010	.250	X			
R0.156	+/-0.010	.156	X			
Ø0.098	+0.005/-0.000	.100	X			
0.040	+/-0.005	.039	X			

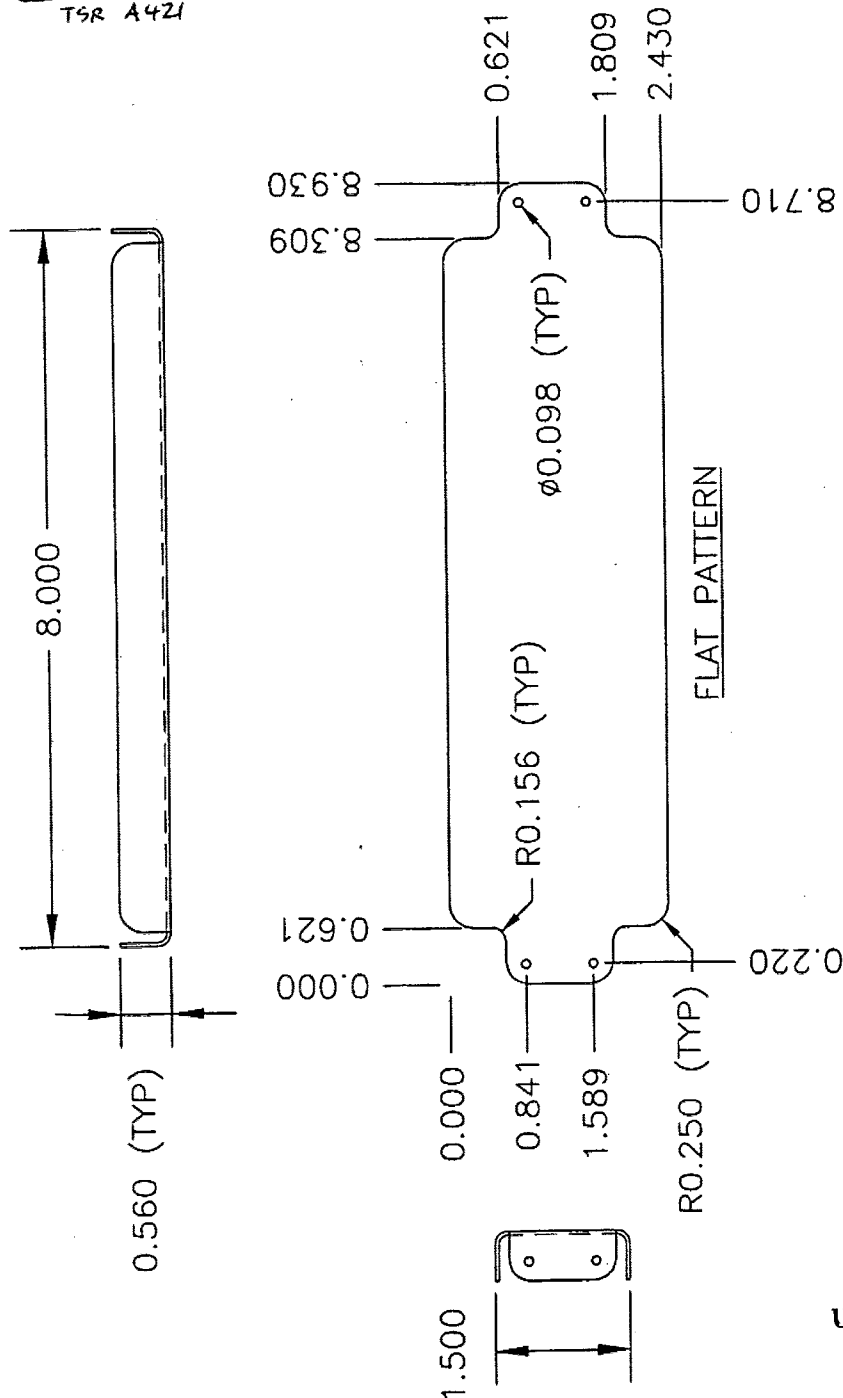
Measured by: EB	Audited by: S	Prototype Approval:	N/A
Date: 9-5-19	Date: 09/05/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	[Signature]



DESIGN <i>JA</i>	DRAWN BY <i>Bw</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>LE</i>	APPROVED <i>JA</i>	DRAWING NO. D2606	REV. A SHEET 1 OF 1
DATE 97.10.23		TITLE CONSOLE BRACKET	SCALE 1:2
A	97.10.23	D2606 WAS D206-547-27	
AI <i>CPH</i>	02.06.04	ADD FINISH	

RELEASED
97.11.04 KE
TSR A421



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

SERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK
PROFILE CONTROLLED BY FOLIO H2606
BEND RADIUS 0.093
FINISH: CHEMICAL CONVERSION COAT PER DART Q51 005